

Work Order ID 139173

November 16, 2015 10:25:05 AM

139173

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4406-041  Accept *N1900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Wearplate Assembly
 Start Date: 11/16/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/30/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SU Date: 20151116 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	DAS
D4406	C	9 <u>has D</u>

150 0.00
 150 1 15-12-22
 Large Fab Memo 0.01 MBL

Large Fab Weld bar as per dwg
 A/R 2059b hardcoat Batch#: 133209
 Weld bar to wearplate as per dwg
 A/R s.s. rod Batch #: 126014

160 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 160 15-12-24
 QC Memo 0.00 DAS
 Quality Control 9
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 139173

November 16, 2015 10:25:05 AM

139173

Page 2

Item ID: D4406-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Wearplate Assembly

Stop

NS2

Start Date: 11/16/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/30/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Memo

0.00

Quality Control

① 15-12-24DAS
9
9-89

170

0.00

170

Small Fab

Memo

0.00

Small Fab

Apply coating as per dwg D4406

1335311DAS
41
9-89

15-12-24

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

①DAS
38
9-89

JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 139173

November 16, 2015 10:25:05 AM

139173

Page 3

Item ID: D4406-041 Accept ***N1900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Wearplate Assembly
 Start Date: 11/16/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/30/2015 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>PRELIM</u> DAS 9-89 Memo LOCATION : FP002 FP.00	0.00 6.00				<u>2</u> xl	<u>ll</u>	<u>16/02/16</u>	<u>DAS 38</u> 9-89 JAN 12 2016
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<u>MJ</u>	<u>MAR 17 2016</u>	

Handwritten signature and date: 16-2-25

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED DAS 9-89 DATE 16-03-16

SM 20151116 ECU 16-518

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

November 16, 2015 10:25:16 AM

Page 1

Work Order ID: 139173

Parent Item: D4406-041

Parent Item Name: Fwd Wearplate Assembly

139173

D4406-041

Start Date: 11/16/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD
12.02.06 as per dwg revPB1 DD verf:EC

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4406-1		Manufactured	No				Each	15.0000		1			
---------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

D4406-1

Plate

15-12-22

JBL

Location	Loc Qty	Loc Code
WA001	15	
101544	2	
136583	12	
98745	1	

D4407-1

Manufactured No

150

Each

30.0000

2

2

D4407-1

Bar

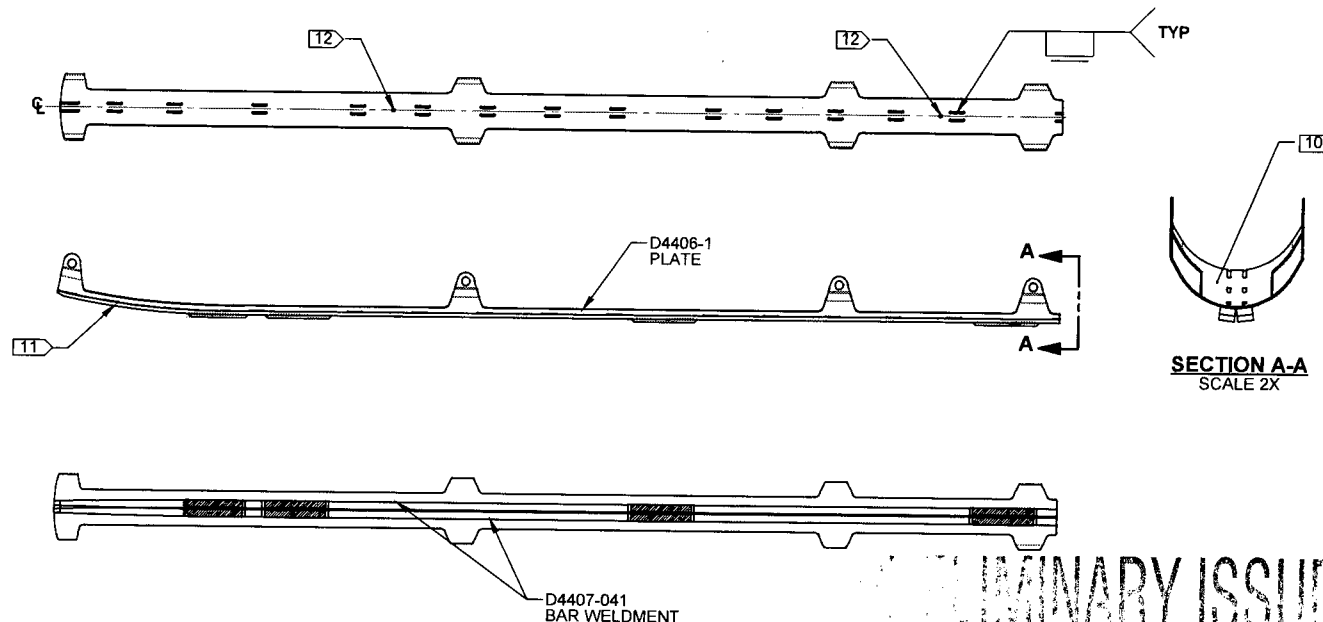
Location	Loc Qty	Loc Code
WA001	24	
136437	24	
WA002	6	
127387	6	

D 4407-041

139187+8

EL 15/12-22

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4406-041	FWD WEARPLATE ASSY
1	1	D4406-1	PLATE
2	2	D4407-041	BAR WELDMENT



D4406-041 FWD WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.38 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING. NOTCH D4407-1 BARS AS REQUIRED
- 12) TRANSFER $\phi 0.188$ HOLES FROM D4406-1 TO D4407-041

20151116 139175 SW

D	D4407-041/-043 BAR WELDMENT WAS D4407-1/-3 BAR, HARDCOAT SURFACING MOVED TO D4407	DB	15.10.14
C	REDESIGNED WITH SHORTER CUTS. NOTE 8 ADDED, 0.18 WAS 0.13 (REF NCR12-2031)	AJS	13.03.11
B	REMOVE TOOLING HOLES FOR -1/-3; REDESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	DB		
CHECKED	AJS		
MFG. APPR.	DD		
APPROVED			
DE APPR.			
DATE	15.10.14		

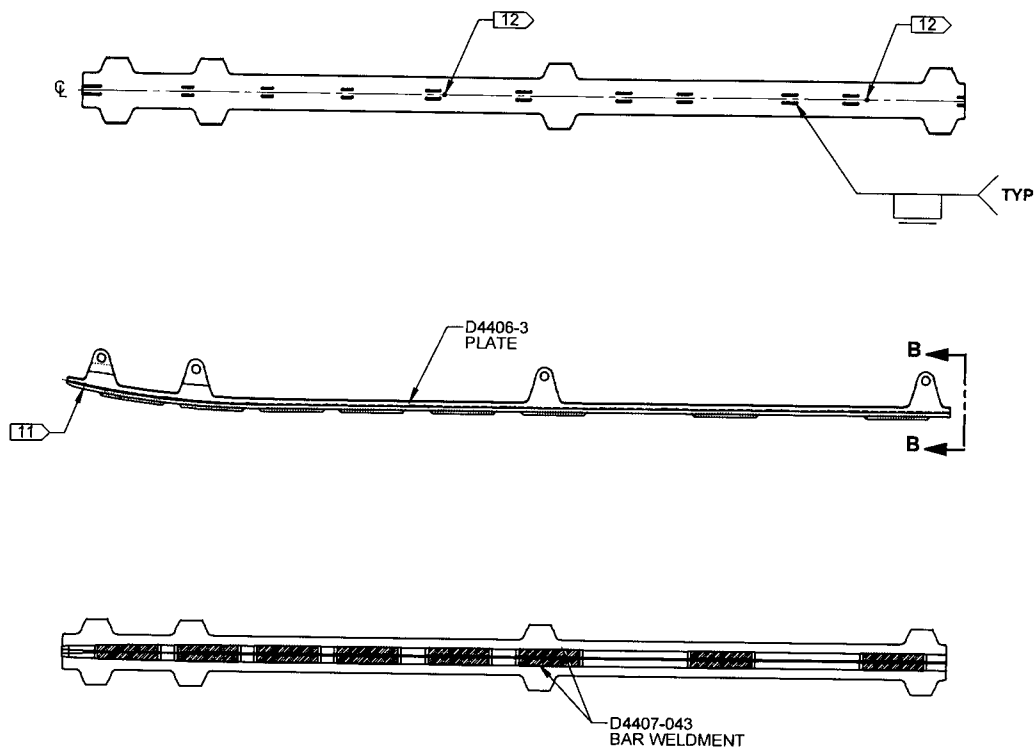
PRELIMINARY ISSUE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4406
TITLE
WEARPLATE ASSY
REV. D
SHEET 1 OF 5
SCALE
NTS

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4406-043	WEARPLATE ASSY
1	1	D4406-3	PLATE
2	2	D4407-043	BAR WELDMENT



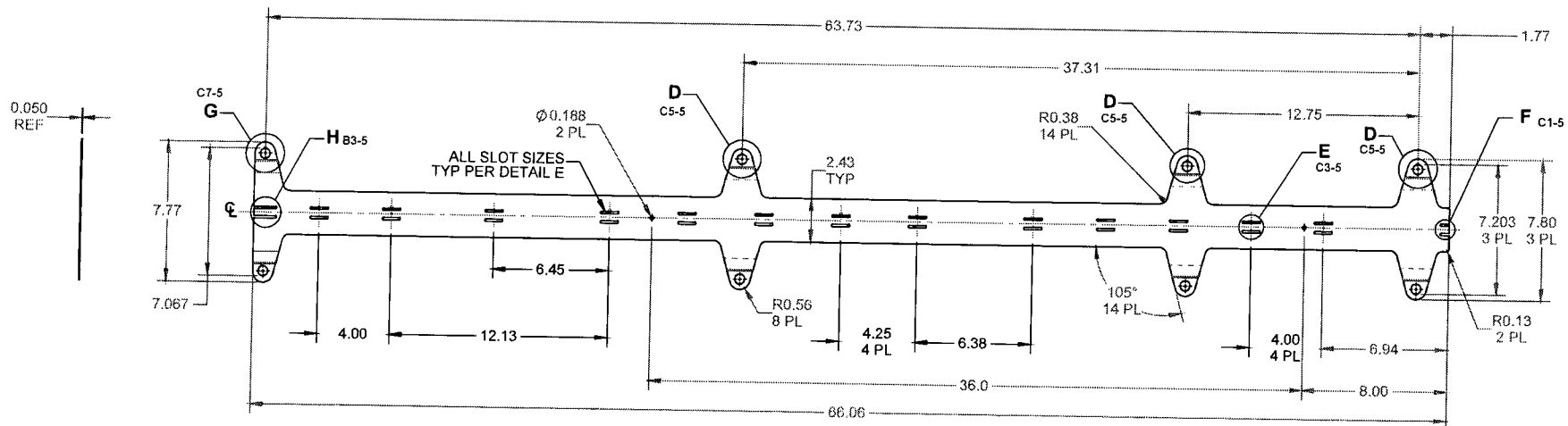
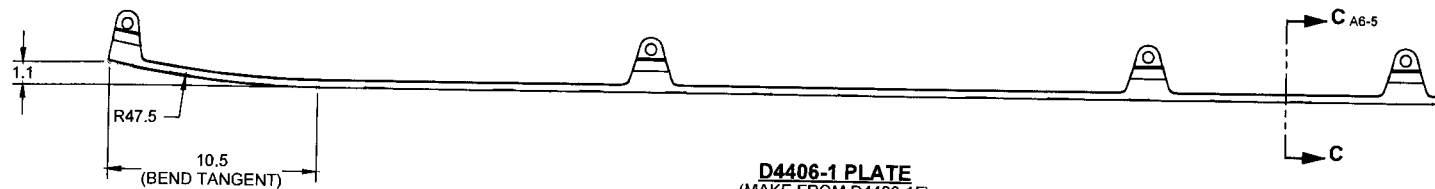
D4406-043 AFT WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 11.02 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING. NOTCH D4407-043 BARS AS REQUIRED
- 12) TRANSFER $\phi 0.188$ HOLES FROM D4406-3 TO D4407-043

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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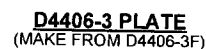


NOTES:

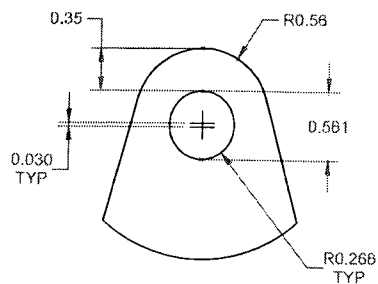
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	15.10.14	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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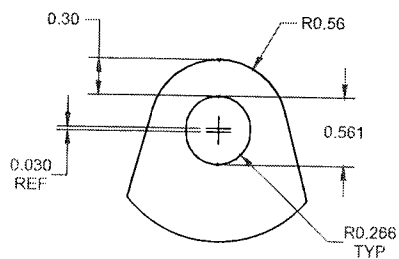


DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. 1
MFG. APPR.	DD	D4406	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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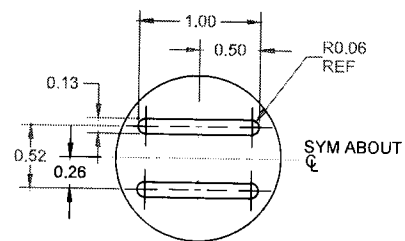
DETAIL G
SLOT DETAIL TYP
SCALE 6X

C7-3
C2-4
C3-4



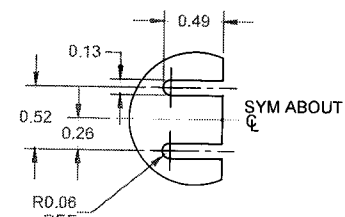
DETAIL D
SLOT DETAIL TYP
SCALE 6X

C2-3
C3-3
C5-3
C5-4
C6-4



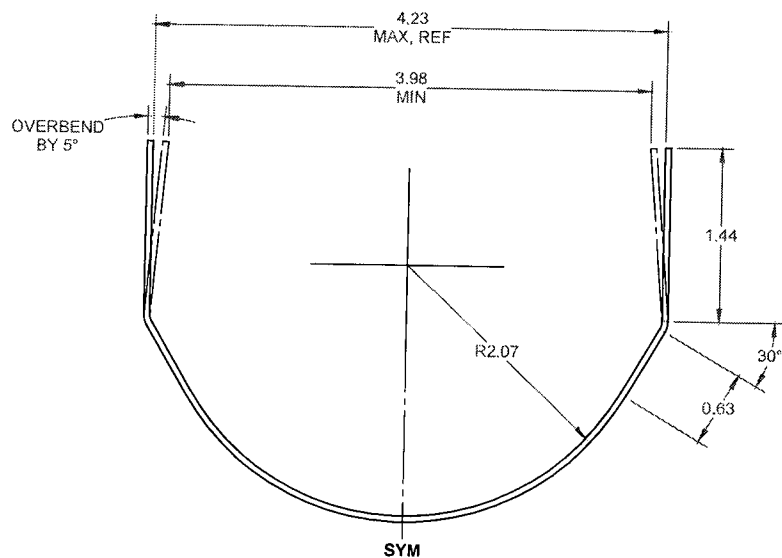
DETAIL E
SLOT DETAIL TYP
SCALE 6X

C2-3
C4-4



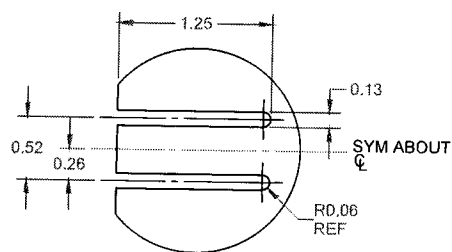
DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-3
B7-4



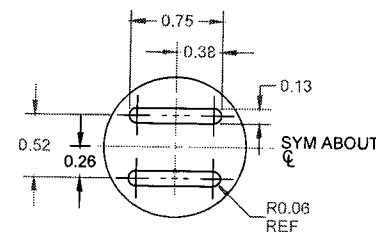
DETAIL C
DETAIL TYP
SCALE 6X

D2-3
D6-4



DETAIL H
SLOT DETAIL TYP
SCALE 6X

C7-3
B1-4



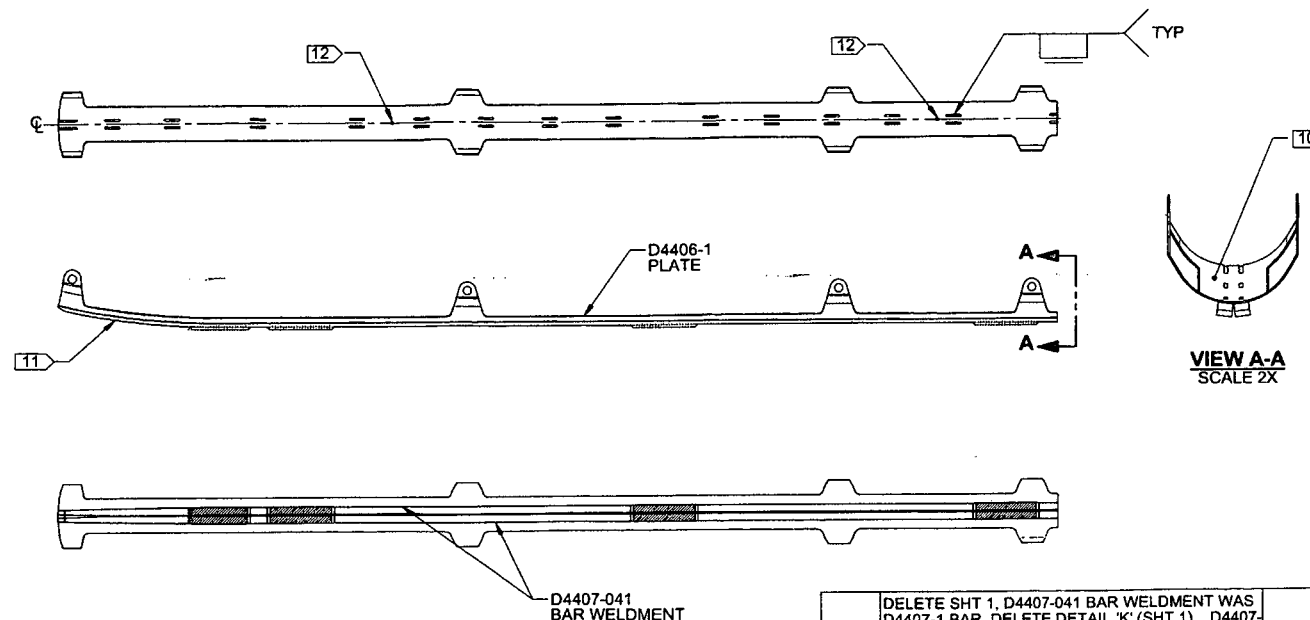
DETAIL J
SLOT DETAIL TYP
SCALE 6X

C4-4

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	15.10.14	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D4406-041	FWD WEARPLATE ASSY
1	1	D4406-1	PLATE
2	2	D4407-041	BAR WELDMENT



D4406-041 FWD WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) N/A

- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING.
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-041

D	DELETE SHT 1, D4407-041 BAR WELDMENT WAS D4407-1 BAR, DELETE DETAIL 'K' (SHT 1), D4407-043 BAR WELDMENT WAS D4407-3 BAR, DELETE DETAIL 'L' (SHT 2), REMOVE NOTE 9 (SHT 1&2), NOTE 10; TEXTURED COATING WAS ROCKGUARD (SH 1&2), NOTE 12; D4407-041 WAS D4407-1 (SHT 1), D4407-043 WAS D4407-3 (SHT 2), REMOVE NOTE 13 (SHT 1&2)	DB	15.10.14
C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED, SHT 5 FWD SLOT SIZES WERE 0.88 (REF NCR12-2031)	AJS	13.03.11
B	REVISE BILL OF MATERIAL; ADD NOTE 13/14 & REVISE NOTE 9 SHT 2&3; MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	DB		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	15.10.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

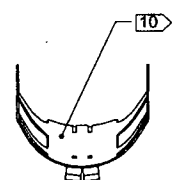
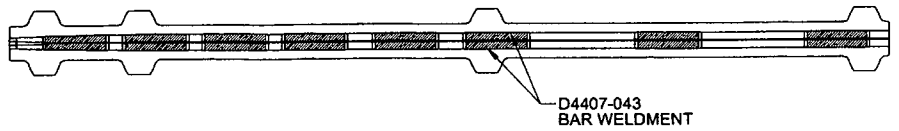
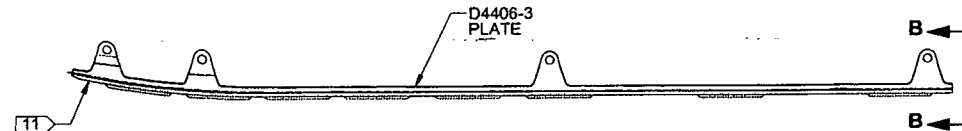
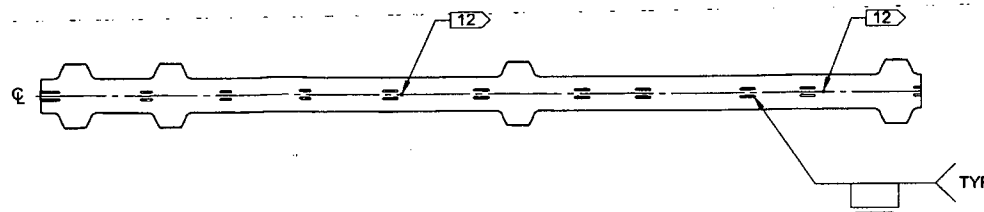
DRAWING NO. **D4406** REV. D
SHEET 1 OF 5
SCALE
NTS

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2016-02-08
EEN 16-518

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4406-043	WEARPLATE ASSY
1	1	D4406-3	PLATE
2	2	D4407-043	BAR WELDMENT



VIEW B-B
SCALE 2X

D4406-043 AFT WEARPLATE ASSY

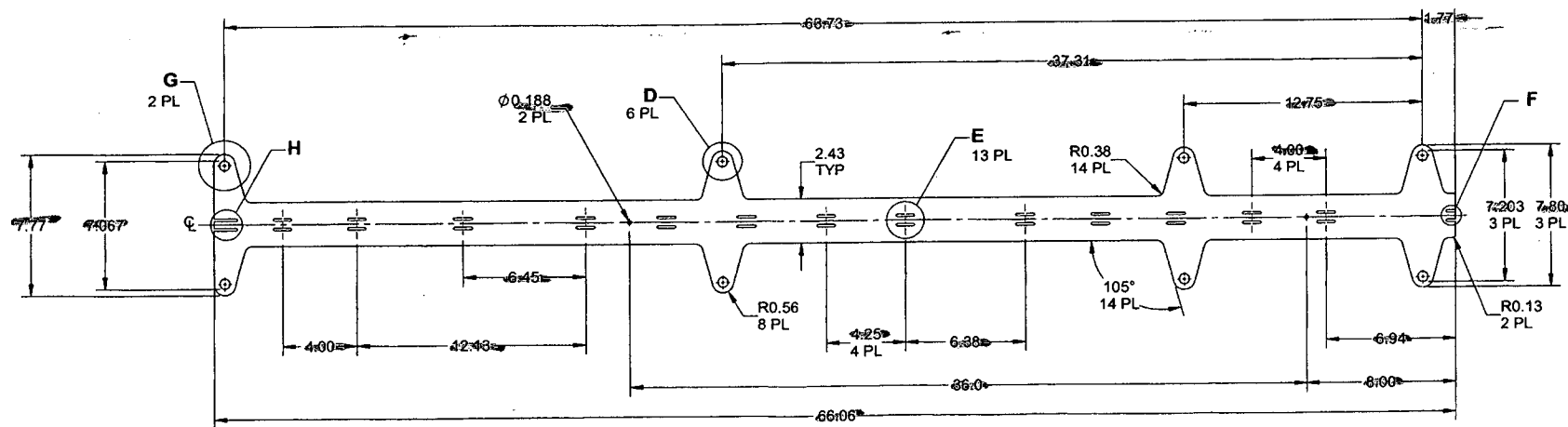
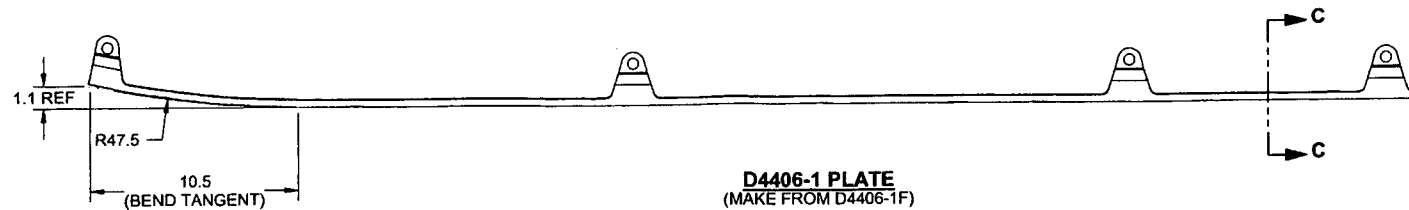
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.70 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING.
- 12) TRANSFER $\phi 0.188$ HOLES FROM D4406-3 TO D4407-043

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.10.14	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

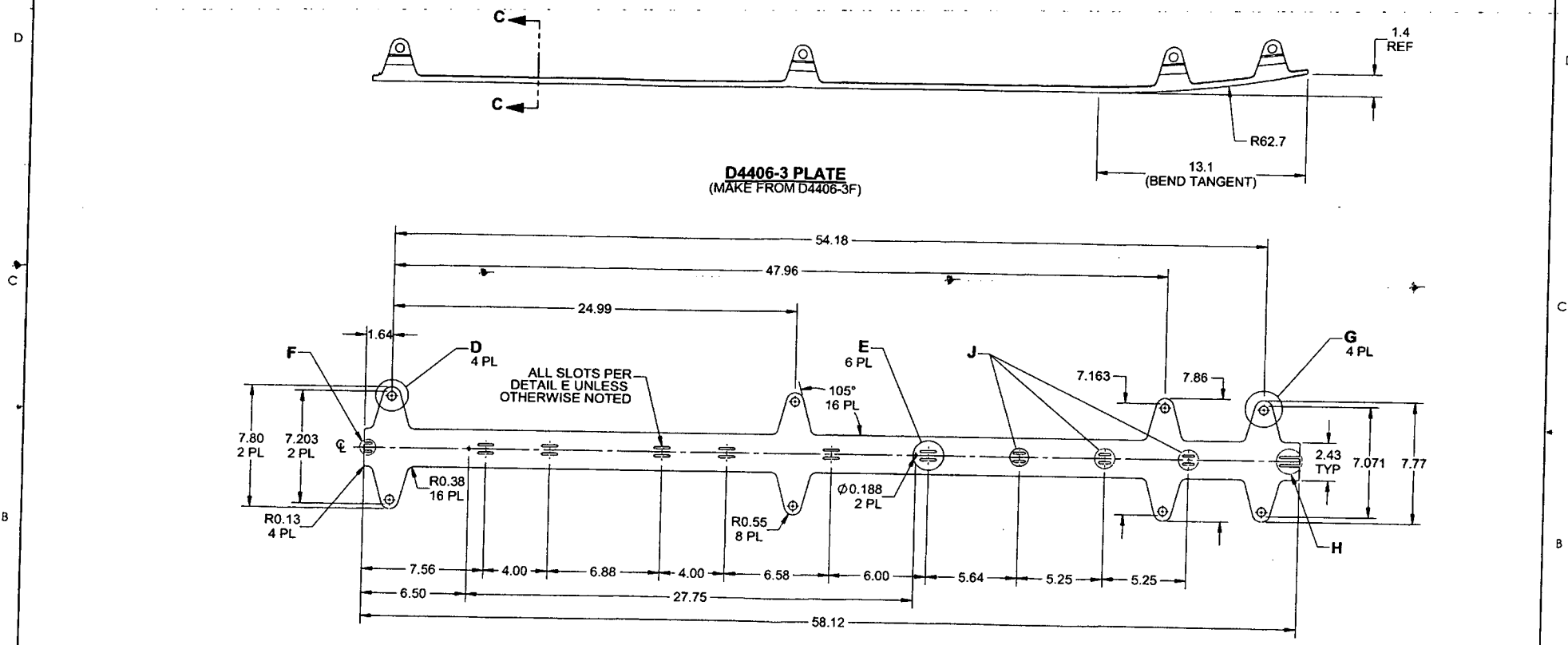
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

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DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D4406-3 PLATE
(MAKE FROM D4406-3F)

D4406-3F FLAT PATTERN

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.5 lbs

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CHECKED	ML	
MFG. APPR.	DD	
APPROVED	WM	
DE APPR.	DS	REV. D
DATE	15.10.14	SHEET 4 OF 5
		SCALE NTS

A

B

C

D

A

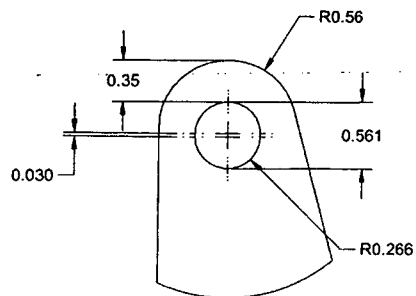
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C

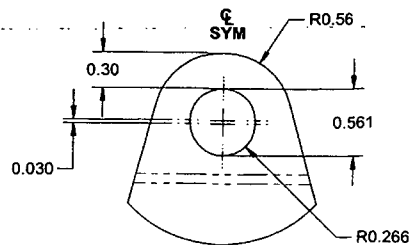
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8 7 6 5 4 3 2 1

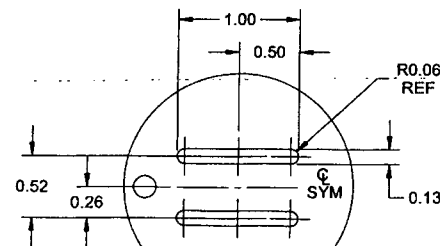
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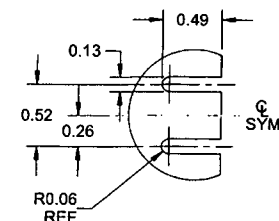
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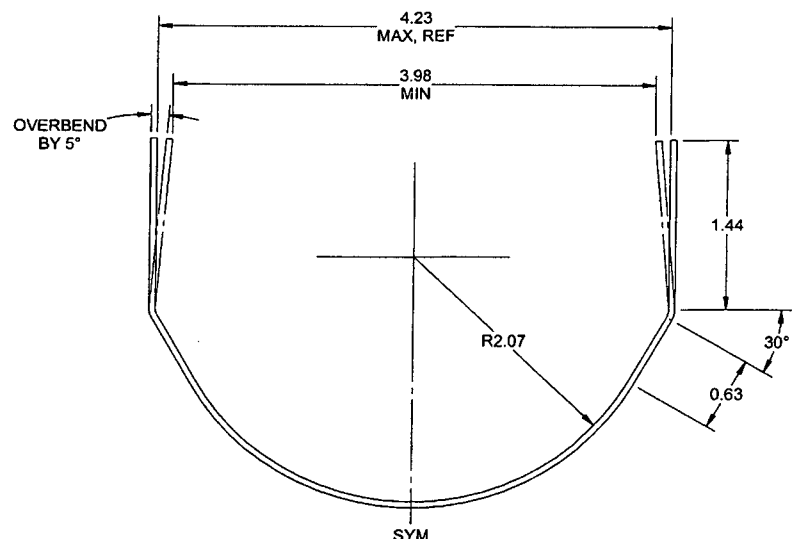
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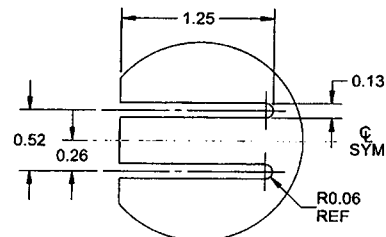
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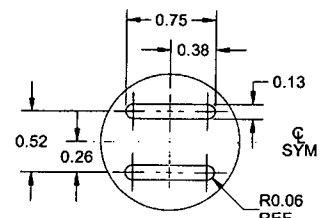
DETAIL F
SCALE 6X



DETAIL C
DETAIL TYP
SCALE 6X



DETAIL H
SCALE 6X



DETAIL J
SCALE 6X

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CHECKED	ML	DRAWING NO. D4406
MF.G. APPR.	DD	REV. D
APPROVED	WM	SHEET 5 OF 5
DE APPR.	DS	SCALE
DATE	15.10.14	NTS
TITLE WEARPLATE ASSY		
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8 7 6 5 4 3 2 1